

Work Order ID 136679-2
Wednesday, September 02, 2015 2:44:17 PM

136679

Page 1

Item ID: D3886-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug Assembly

Start Date: 9/23/2015 Start Qty: 8.00

Required Date: 9/28/2015 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLS Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3886	B
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100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

FLOW WATER JET

1-Cut as per Dwg D3886-3

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

0.01

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

(10)

09/15/10/07

(10)

09/15/10/07

Wednesday, September 02, 2015 2:44:17 PM

136679

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Lug Assembly

Start Date: 9/23/2015 Start Qty: 8.00 *g*

Cust Item ID:

Required Date: 9/28/2015 Req'd Qty: 8.00 *g*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC8: Inspect parts - second check

0.00

120

0.00

QC

Memo

Quality Control

DAS
38
9-89
OCT 13 2015

130

0.00

130

0.01

Brake NC

Memo

Brake NC

form as per dwg D3886

DAS
30
9-89

OCT 13 2015

140

QC5- Inspect part completeness to step on W/O

0.00

140

0.00

QC

Memo

Quality Control

AS
38
3-89

OCT 13 2015

Work Order ID 136679

Wednesday, September 02, 2015 2:44:17 PM

136679

Page 3

Item ID: D3886-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug Assembly

Start Date: 9/23/2015 Start Qty: 8.00 *g*

Cust Item ID:

Required Date: 9/28/2015 Req'd Qty: 8.00 *Q*

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00

150

0.03

Large Fab

Memo

Large Fab

Weld as per Dwg D3886 and QSI 004 use DT9626
A/R SS ROD Batch: 126014

A/R SS ROD Batch:

126014

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

0.00

QC

Memo

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

170

0.00

QC

Memo

Quality Control

Work Order ID 136679

Wednesday, September 02, 2015 2:44:17 PM

136679

Page 4

Item ID: D3886-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug Assembly
 Start Date: 9/23/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 9/28/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>m133962</i> Memo	0.00 0.00				2	0	16-03-1	<i>START: 1:35 OV. T: 400° FINISH: 2:05</i> 338
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				(2)			DAS 38 9-88 MAR 02 2016
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <i>51528</i> Memo	0.00 0.00				2		ML5 16-03-02	

Work Order ID 136679

Wednesday, September 02, 2015 2:44:17 PM

136679

Page 5

Item ID: D3886-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug Assembly
 Start Date: 9/23/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 9/28/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.01							
Quality Control									

MCS MAR 03 2016
MCS MAR 02 2016

Picklist Print

Page 1

Wednesday, September 02, 2015 2:44:16 PM

Work Order ID: 136679

136679

Parent Item: D3886-041

D3886-041

Parent Item Name: Lug Assembly

Start Date: 9/23/2015

Required Date: 9/28/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S12GA		Purchased	No			100	sf	70.2313	0.1472	1.1776			
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M304S12GA

304/316 0.100" Sheet

**

09/15/10/08

Location

Loc Qty

Loc Code

MAT019

70.2313

70.2313

m131322

1.5

D3886-1

Manufactured No

150

Each

20.0000

1

8

D3886-1

Lug

**

16-01-11

Location

Loc Qty

Loc Code

WA002

20

20

133790

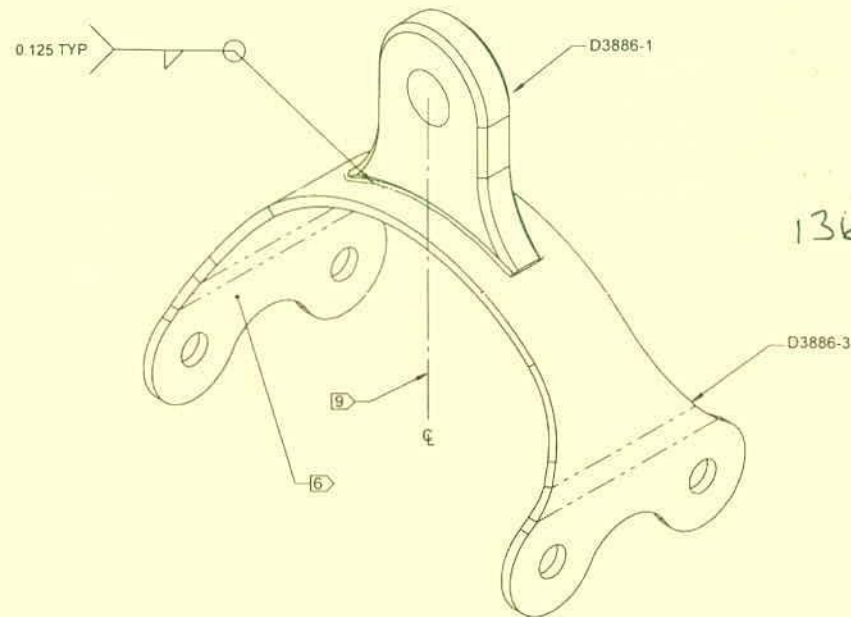
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137743

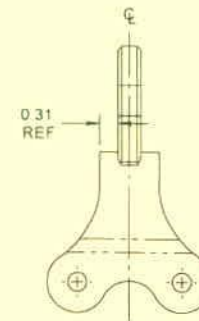
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16-02-01
1BL

ITEM	QTY	P/N	DESCRIPTION
1	X	D3886-041	LUG ASSEMBLY
2	1	D3886-1	LUG
3	1	D3886-3	BRACKET



136679 MLS
1509-08



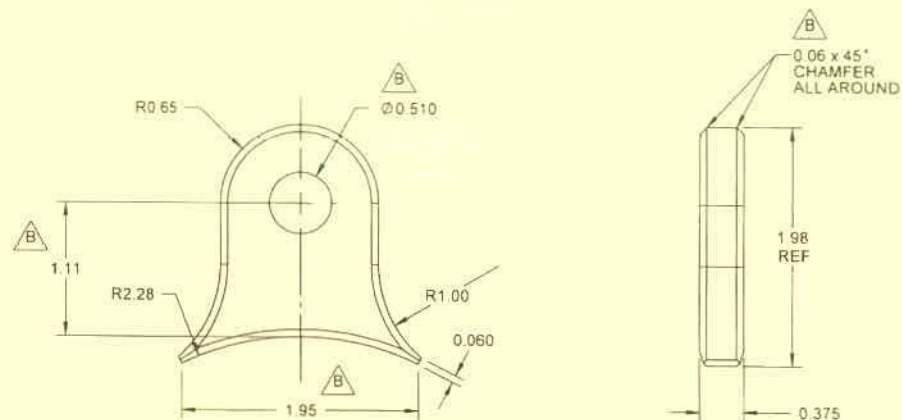
D3886-041 LUG ASSEMBLY

RELEASED
9/17/10

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005.4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3886-041" AND BATCH NUMBER USING FINE POINT PERMANENT INK MARKER ON UNDERSIDE OF PART
- 7) WEIGHT: 0.53 lbs
- 8) WELD PER DART QSI 004
- 9) BOTH PARTS CENTER SHOULD BE IN LINE WITH THE C

B	RE-DESIGN D3886-1 (ZN B4-2); RE-DESIGN D3886-3 (ZN A4-3); REVISED D3886-3F (ZN B4-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG APPR	RF	D3886	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR	RF	LUG ASSEMBLY	NTS
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D3886-1 LUG

NOTES

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR (REF. DART SPEC. M304B0.750X2.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

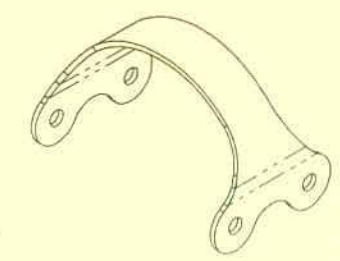
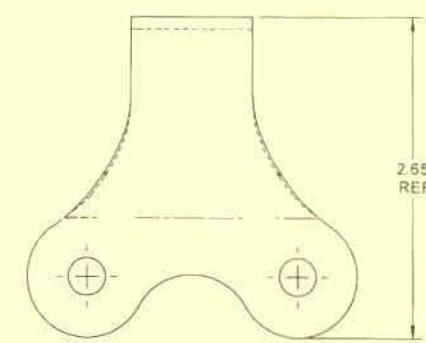
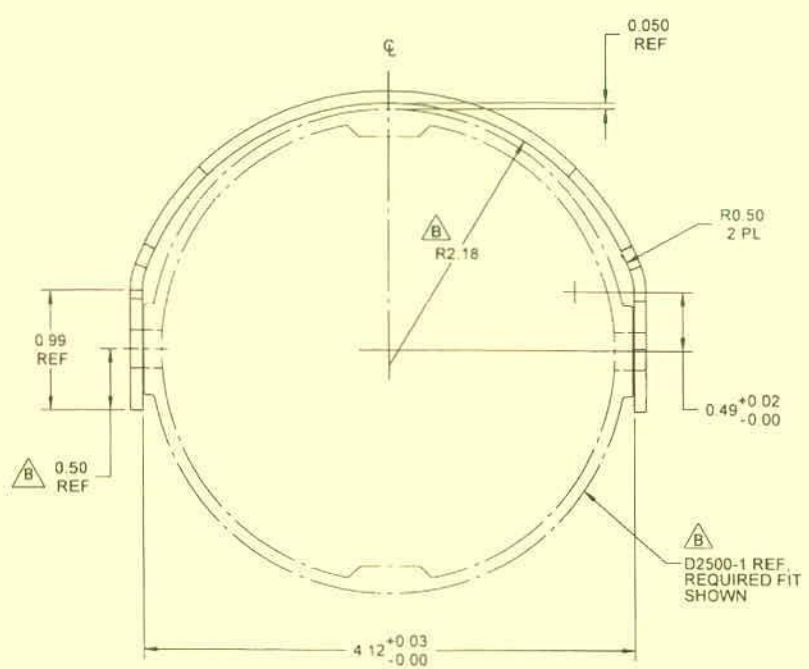
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09/07/03

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MFG APPR	<i>RF</i>	D3886	SHEET 2 OF 4
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8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A

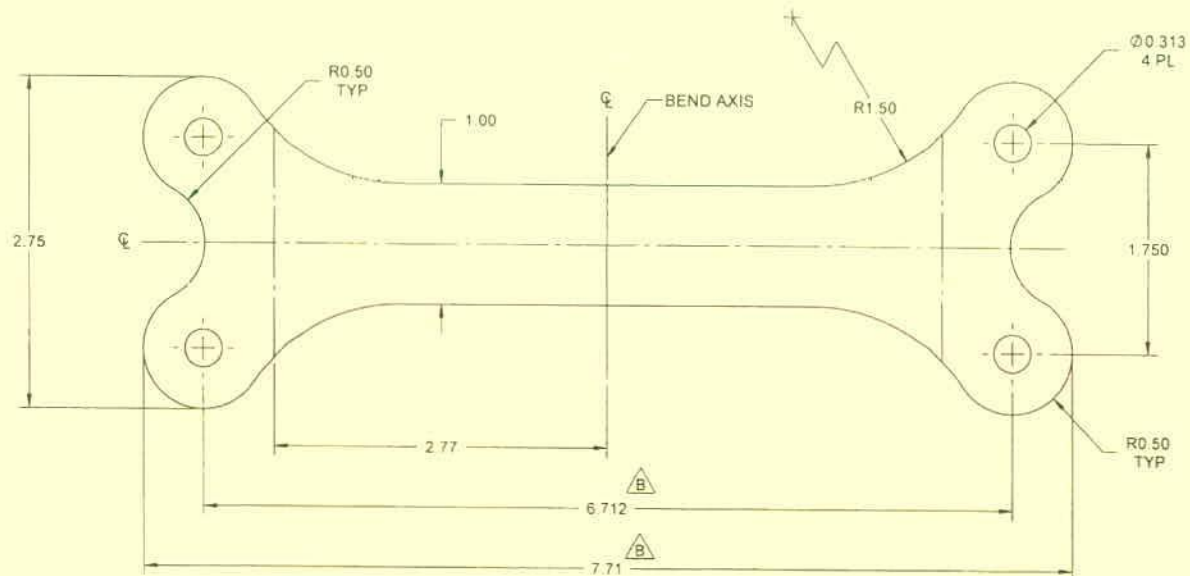


D3886-3 BRACKET B
(MAKE FROM D3886-3F)

RELEASED
09/07/15

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MFG APPR	<i>[Signature]</i>		SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR	<i>[Signature]</i>	LUG ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



D3886-3F FLAT PATTERN $\triangle B$

RELEASED
8/27/15

NOTES

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 12 GAUGE (0.100) THICK. (REF DART SPEC. M304S12GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.30 lbs

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV B
MFG APPR.	<i>[Signature]</i>	D3886	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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